

Date: Monday, 5/15/2006 11:12:16 AM
 User: Kim Johnston

(5)
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 27118					
Estimate Number	: 10939					
P.O. Number	: N/A			Part Number	: D29382	
This Issue	: 5/15/2006	S.O. No.	: N/A	Drawing Number	: D2938 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: 5/15/2006	Type	: MACHINED PARTS	Drawing Revision	: B	
Previous Run	: 26370			Material	: N/A	
Written By	<u>See JLS Comment Below</u>			Due Date	: 5/30/2006	
Checked & Approved By	<u>JLS 06.05.15</u>			Qty:	8 Um: Each	
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length (D6101-003)	Batch No: <u>B24781</u>
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet 5-Deburr	<u>JL/SN 06.06.09</u>
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	<u>JL/SN 06.06.09</u>
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	<u>JL/SN 06.06.09</u>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>ML 06/07/2004</u>
			8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

 NoDQA: 

Date: 06/07/08

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

Date: Monday, 5/15/2006 11:12:17 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 27118

Part Number: D29382

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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540

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SAD

06/07/25

~~72~~ 8

7.0	POWDER COATING	POWDER COATING
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(8)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC
PL 06/07/25

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT

MR 06/07/27

(8)

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 476

AL 06/07/27

(8)

10.0	DC	DOCUMENT CONTROL
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(8)

Comment: DOCUMENT CONTROL

Inspection Level 21

AL 06/07/28

Job Completion



06.07.28

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27118
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.119	.117	.117		
B	0.100	0.140		.116	.119	.119	.119		
C	0.100	0.140		.118	.117	.117	.118		
D	0.210	0.230		.224	.228	.225	.227		
E	1.245	1.255		1.256	1.250	1.250	1.256		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.503	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.125	.125	.124		
O	0.540	0.560		.549	.549	.549	.549		
P	0.490	0.510		.499	.492	.499	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.254	.254	.254	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.262	1.263	1.264	1.263		
Y	1.565	1.585		1.574	1.576	1.577	1.573		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD	Audited by:	✓
Date:	06.06.08	Date:	06/07/08

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#

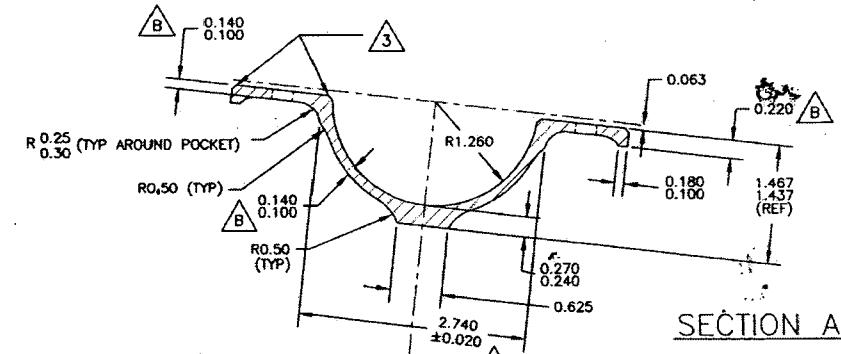
DART AEROSPACE LTD	Work Order:	27118
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. B and record below:

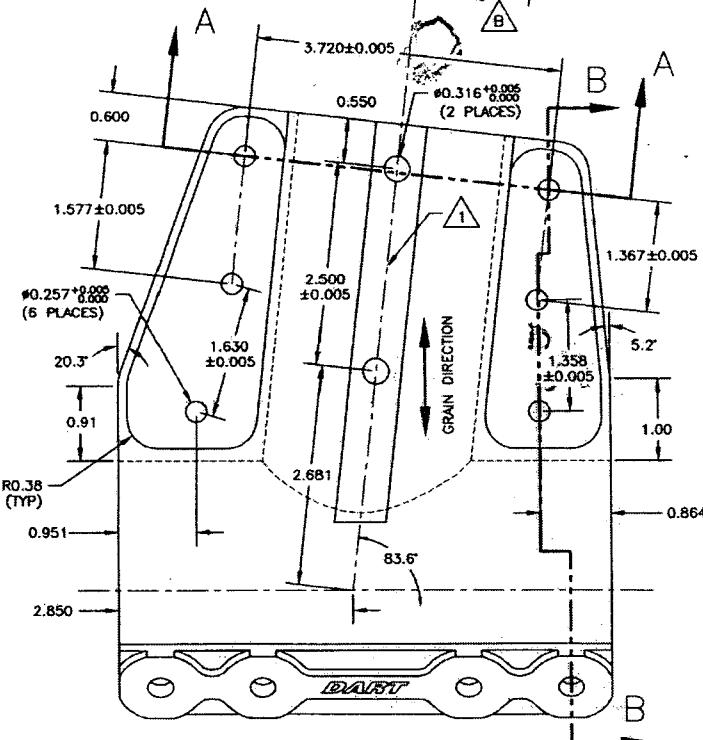
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.119	.117	.116	.117		
B	0.100	0.140		.121	.117	.118	.117		
C	0.100	0.140		.117	.115	.115	.115		
D	0.210	0.230		.227	.228	.228	.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.514	.514	.514	.514		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.125	.125	.124	.125		
O	0.540	0.560		.549	.548	.549	.549		
P	0.490	0.510		.495	.497	.498	.497		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.742	2.742	2.742	2.742		
S	0.240	0.270		.255	.255	.254	.254		
T	0.100	0.180		.142	.142	.143	.142		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690						
X	1.250	1.270		1.264	1.259	1.265	1.265		
Y	1.565	1.585		1.573	1.573	1.578	1.574		
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SA	Audited by:	9/4
Date:	06/06/09	Date:	06/07/24

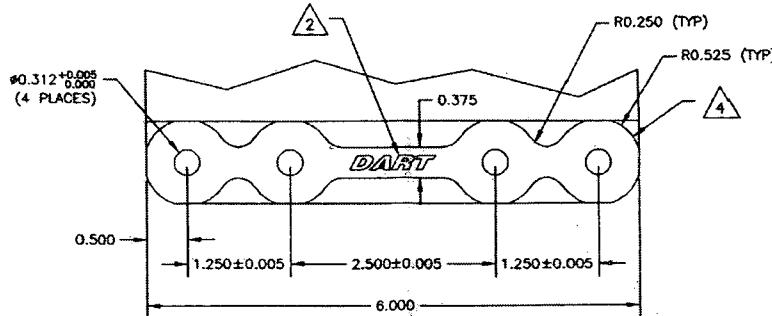
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	#



SECTION A-A



SECTION B-B



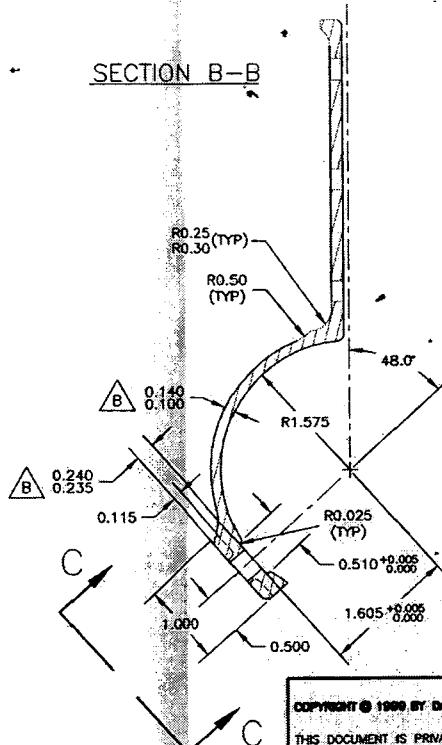
VIEW C-C

D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENgrave part and batch number in this area 0.010 to 0.015 deep
- 2 Engrave DART logo to max depth of 0.005 with min rad 0.250
- 3 Chamfer 0.050° x 45° around this surface (typical 2 places)
- 4 Chamfer 0.050° x 45°

RELEASED
00.05.29



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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99-11-12	NEW ISSUE
DESIGN	DRAWN BY KF	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938
DATE		REV. B SHEET 1 OF 1 TITLE SADDLE OUTSIDE SCALE 23

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NO. 27118

